

Work Order ID 116372-1

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116372-1

Page 1

Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 6/18/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 6/18/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

7.10

Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D
DSI9690	A

MLC 1407-22

100	Document Control	0.00	DAS
100	DOCUMENT CONTROL		06
DC	Memo	0.00	9-89

JUL 23 2014

Doc.Control -USB or Paperwork Photocopy bluefile and create labels per PPP D350-588-041 CHG003

110	PURCHASING	0.00
-----	------------	------

110	PURCHASING	0.00
Purchasing	Memo	
Purchasing	Issue P/O: <u>24168</u>	

CL 14/05/12 ①

Description: D2445 Baggage Door
Supplier: Delastek
Ship to Delastek (1) D0588-041 label
Certification of Conformity and process sheet from Delastek is required.

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Item ID: D350-588-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Door Assembly

Start Date: 6/18/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/18/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.00							
Packaging	Ensure Certificate of Conformity & Process Sheet are attached								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140	Small Fab	0.00							
140									
Small Fab	Memo	0.00							
Small Fab	Assemble all of the above parts as per Dwg D350-588								

DAS

27

9-89

14/6/18

14/6/18 (1)

1

V DAS 28 9-89 JUL 10 2014

1 CR 14-07-10

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Item ID: D350-588-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Door Assembly

Start Date: 6/18/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 6/18/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

CAS

150

QC

Memo

0.00

Quality Control

155

Pick Kit

0.00

155

Packaging

Memo

0.00

Packaging

160

QC4- 100% Inspect kits for completeness

0.00

160

QC

Memo

0.00

Quality Control

JUL 23 2014

DAS
28
9-89/X DAS
28
9-89 JUL 11 2014 DAS
31
9-89

A

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Item ID: D350-588-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Door Assembly

Start Date: 6/18/14 Start Qty: 1.00

1

Cust Item ID:

Required Date: 6/18/14 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>621</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

1x JUL 23 2014

MLJ 14-07-24

14-7-23

Picklist Print

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Work Order ID: 116372-1

116372-1

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as
per DSI9414 DD verified by:EC IPP Rev:R add pick kit DD
10.03.29 verified by:EC IPP REV:S 14.04.28 AS PER
DSI9690 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7		Purchased	No			155	Each	262.0000	2	2	DAS 28 9-89	JUL 11 2014	
AN526C1032R7													
Screw													
				<u>Location</u>				<u>Loc Qty</u>					
				ST346				262					
				128831				8		2X			
				M126175				6					
				M128403				248					
AN526C832R8		Purchased	No			155	Each	239.0000	8	8	DAS 28 9-89	JUL 11 2014	
AN526C832R8													
Screw													
				<u>Location</u>				<u>Loc Qty</u>					
				ST345				239					
				125388				14					
				m127817				2					
				m128403				223		8X			
AN526C832R9		Purchased	No			140	Each	809.0000	8	8	DAS 28 9-89	JUL 10 2014	
AN526C832R9													
Screw													
				<u>Location</u>				<u>Loc Qty</u>					
				ST327				400					
				M129391				400					
				ST345				409					
				M128429				409		8X			

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Work Order ID: 116372-1

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

D2143

Manufactured No

140 Each

8.0000

1 1

D2143

Hinge Bracket

DAS
28
9-89

JUL 10 2014

Location

Loc Qty

Loc Code

ST003

8

100918

8

D2144

Manufactured No

140 Each

7.0000

1 1

D2144

Hinge Doubler

DAS
28
9-89

Location

Loc Qty

Loc Code

ST003

7

100467

7

D2150

Manufactured No

155 Each

52.0000

2 2

D2150

Packer Doubler, Hinge

DAS
28
9-89

JUL 11 2014

Location

Loc Qty

Loc Code

ST003

52

106861

8

110792

24

114336

20

D2151

Manufactured No

155 Each

26.0000

2 2

D2151

Packer Doubler

DAS
28
9-89

DAS
31
9-89

121825

Location

Loc Qty

Loc Code

ST003

26

102125

1

106821

20

114304

5

DAS
28
9-89

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

D2153 Manufactured No 155 Each 35.0000 1 1

D2153

Door Prop

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

4

85865

4

ST260

31

100934

1

110755

14

114286

16

**

JUL 11 2014

DAS
28
9-89

DAS
31
9-89

D2154 Manufactured No 155 Each 29.0000 1 1

D2154

Bracket, Stud

DAS
06
9-89

Location

Loc Qty

Loc Code

ST003

29

110134

7

114213

22

**

DAS
28
9-89

DAS
31
9-89

D2237 Manufactured No 155 Each 75.0000 2 2

D2237

Striker Plate

DAS
06
9-89

Location

Loc Qty

Loc Code

ST005

75

108708

1

112911

7

116707

67

**

DAS
28
9-89

DAS
31
9-89

D2445P Purchased No 110 Each 0.0000 1 1

D2445P

Aft Door Assembly

**

116372-1

[Signature]

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

D2461

Manufactured No

155 f

481.4700 7.25 8

DAS
28
9-89

JUL 11 2014

D2461

Seal(Per Foot)

DAS
06
9-89

1X87"
SMD 14/11

Location

Loc Qty

Loc Code

ST402

481.47

102517

85.97

114238

395.5

8X

DAS
31
9-89

(D2461-0870) cut (1) at 87.00"

**** per kit****

D2463

Manufactured No

140 f

551.0637 7.25 8

**

DAS
28
9-89

JUL 10 2014

D2463

1/2" Seal (\$Per Foot)

1X87"
SMD 11/10

Location

Loc Qty

Loc Code

ST402

51.063684

110718

51.063684

ST420A

500

115701

500

8X

(D2463-0870) cut (1) at 87.00"

**** per kit****

D2585

Manufactured No

140 Each

82.0000 2 2

**

DAS
28
9-89

D2585

Latch Clamp

Location

Loc Qty

Loc Code

ST008

82

108520

1

112571

1

114114

1

114400

79

2X

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

D2586

Manufactured No

140

Each

47.0000

2

2

D2586

Door Latch

DAS
28
9-89

JUL 10 2014

Location

Loc Qty

Loc Code

FG

9

100607

2

114985

1

83893

5

95760

1

ST198A

38

108573

24

113641

5

114985

4

119746

5

2x

D2589

Manufactured No

155

Each

5.0000

1

1

D2589

Keys, Key Chain

DAS
28
9-89

JUL 11 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

ST008

5

58194

5

1x

D2621

Manufactured No

140

Each

20.0000

2

2

D2621

Latch Plate

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

2

88616

2

ST008A

18

108138

3

115195

15

2x

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

D2690-17 Manufactured No

155 Each 31.0000 1

D2690-17
Cable

DAS
28
9-89
JUL 11 2014
DAS
31
9-89

Location	Loc Qty	Loc Code
ST009	31	
108397	1	
110028	6	
112206	6	
114912	5	
116739	6	
120107	6	
94470	1	

DAS
06
9-89

IX

D2857-1 Manufactured No

140 Each 27.0000 1

D2857-1
Hinge Bracket

DAS
28
9-89
JUL 10 2014

Location	Loc Qty	Loc Code
FG	5	
82261	4	
91914	1	
ST012	22	
110247	1	
113744	21	

IX

D2857-2 Manufactured No

140 Each 35.0000 1

D2857-2
Hinge Bracket

Location	Loc Qty	Loc Code
FG	3	
78904	3	
ST012	32	
100769	1	
108401	7	
114154	24	

IX

DAS
28
9-89

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Shop Packet Print

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Work Order ID: 116372-1

116372-1

Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

D2858-1

Manufactured No

155

Each

31.0000

1

1

DAS
28
9-89

JUL 11 2014

D2858-1

Hinge Bracket

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

2

77019

2

ST012

29

110032

5

114144

24

D2858-2

Manufactured No

155

Each

29.0000

1

1

DAS
28
9-89

DAS
31
9-89

D2858-2

Hinge Bracket

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

2

77020

2

ST012

27

105555

3

113735

24

D5080-041

Manufactured No

155

Each

41.0000

2

2

DAS
28
9-89

DAS
31
9-89

D5080-041

Striker Plate Assembly

DAS
06
9-89

Location

Loc Qty

Loc Code

prelim

1

115524

1

ST130

40

119725

40

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Work Order ID: 116372-1

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

116372-1

D350-588-041

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

FG-778150-550-ROL

Purchased

No

155

sf

2,201.000

1

1

***FG-778150-550-ROL ***

7781 9oz Glass 50x125yd

DAS
06
9-89

Location

Loc Qty

Loc Code

CA

2201

M127570

638

M127701

1563

**

DAS
28
9-89

JUL 11 2014

DAS
31
9-89

CUT ONE SQUARE FEET PER KIT

MS20426AD3-4

Purchased

No

155

Each

6,894.000

12

12

MS20426AD3-4

RIVET

DAS
06
9-89

Location

Loc Qty

Loc Code

MF4

265

125578

265

ST334

2917

m127432

2917

ST509

3712

125578

3712

**

DAS
28
9-89

DAS
31
9-89

MS20470AD4-5

Purchased

No

155

Each

3,099.000

18

18

MS20470AD4-5

RIVET, UNIVERSAL HEAD

DAS
06
9-89

Location

Loc Qty

Loc Code

ST336

3099

m126926

255

m128401

1653

m128813

1191

**

DAS
28
9-89

DAS
31
9-89

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Work Order ID: 116372-1

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Purchased

No

140

Each

4,730.000

8

8

MS21042I 08

Nut

DAS
28
9-89

JUL 10 2014

Location

Loc Qty

Loc Code

ST314

2968

123900

58

m128401

1500

m128429

1410

ST508

1663

125445

265

m127410

1398

ST509

99

m127304

99

8x

MS21042L08

Purchased

No

155

Each

4,730.000

10

10

MS21042I 08

Nut

DAS
28
9-89

JUL 11 2014

Location

Loc Qty

Loc Code

ST314

2968

123900

58

m128401

1500

m128429

1410

ST508

1663

125445

265

m127410

1398

ST509

99

m127304

99

10x

DAS
06
9-89

DAS
31
9-89

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Work Order ID: 116372-1

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

140

Each

5,822.000

2

2

MS21042L3

Nut

DAS
28
9-89

JUL 10 2014

Location

Loc Qty

Loc Code

ST314

164

108816

9

M126333

55

M127410

13

M127831

39

M128401

48

ST506

955

123900

955

ST509

4703

M127831

2

M128754

4701

2x

MS21042L3

Purchased

No

155

Each

5,822.000

4

4

MS21042L3

Nut

DAS
28
9-89

JUL 11 2014

Location

Loc Qty

Loc Code

ST314

164

108816

9

M126333

55

M127410

13

M127831

39

M128401

48

ST506

955

123900

955

ST509

4703

M127831

2

M128754

4701

4x

DAS
06
9-89

DAS
31
9-89

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11

Purchased

No

155

Each

344.0000

2

2

MS27039-08-11

SCREW

DAS
28
9-89

JUL 11 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

ST307

18

123352

18

ST506

326

122441

13

123185

1

123900

88

M128770

224

2x

MS27039-1-15

Purchased

No

140

Each

803.0000

2

2

MS27039-1-15

Screw

DAS
28
9-89

JUL 10 2014

Location

Loc Qty

Loc Code

ST306

203

124326

203

ST506

600

m127916

600

2x

NAS1149D0363J

Purchased

No

140

Each

3,427.000

2

2

NAS1149D0363.J

Washer

DAS
28
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

3404

109061

9

m126319

6

m128429

3389

2x

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

155

Each

3,427.000

2

2

NAS1149D0363.I

Washer

DAS
28
9-89

JUL 11 2014

DAS
06
9-89

Location

Loc Qty

Loc Code

GA

23

124392

23

ST510a

3404

109061

9

m126319

6

m128429

3389

2X

NAS1149DN832J

Purchased

No

140

Each

3,194.000

8

8

NAS1149DN832.I

Washer

DAS
28
9-89

JUL 10 2014

Location

Loc Qty

Loc Code

MF4

616

M127255

616

ST277

1000

M129499

1000

ST293

1422

M128948

438

M128429

984

8X

st510

145

124555

145

ST510a

11

M126319

11

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Parent Item: D350-588-041

D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 6/18/14

Required Date: 6/18/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J

Purchased

No

155

Each

3,194.000

16

16

NAS1149DN832.J

Washer

**DAS
28
9-89**

JUL 11 2014

**DAS
06
9-89**

Location

Loc Qty

Loc Code

MF4	616	
M127255	616	
ST277	1000	
M129499	1000	
ST293	1422	
M128948	438	
M128429	984	
st510	145	
124555	145	
ST510a	11	
M126319	11	

16x

**DAS
31
9-89**



DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

RELEASED

06.11.13

CUT 2 PLACES AS PER DETAIL A ON PAGE 2
OR USE D2621 AS TEMPLATE

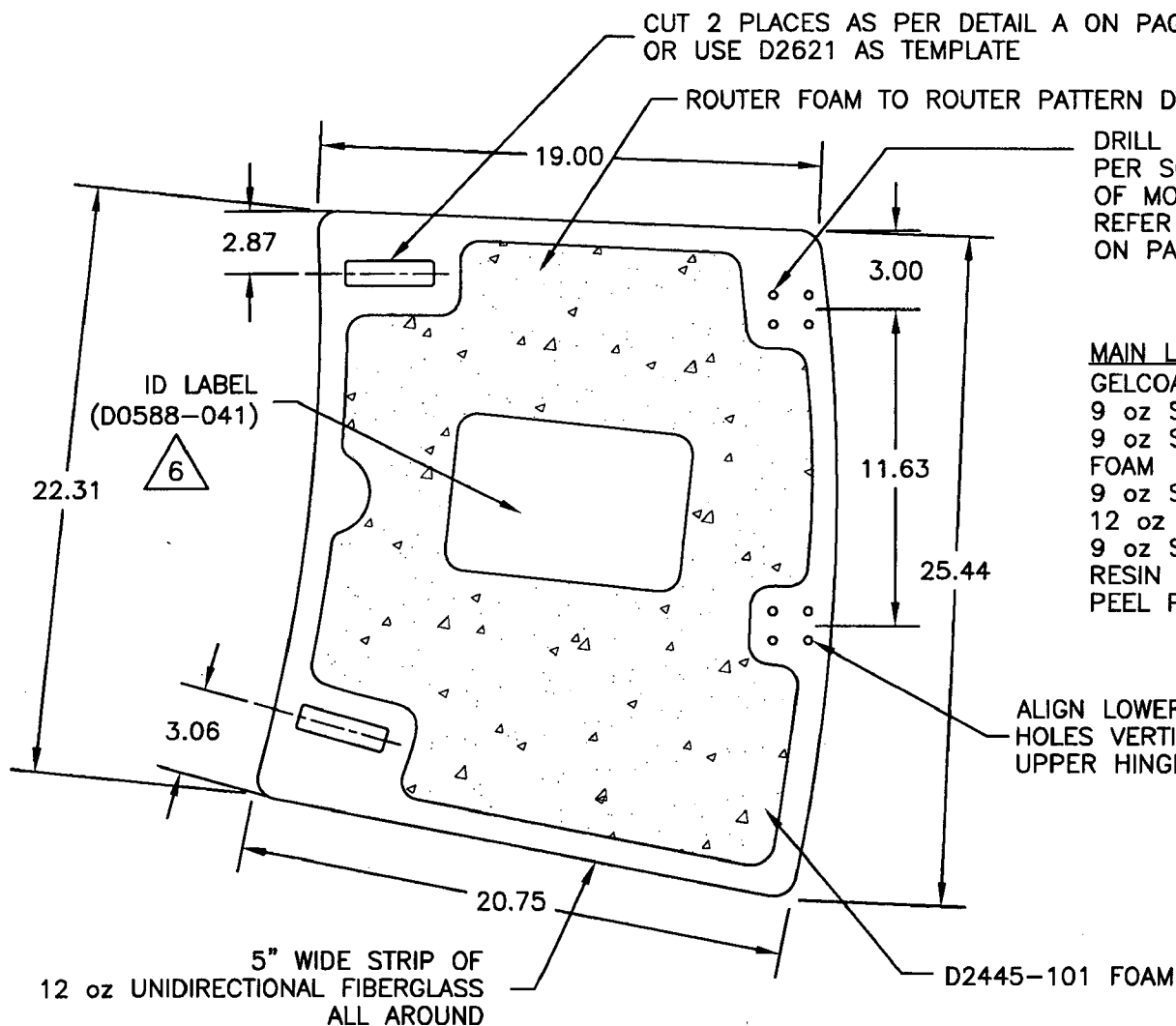
ROUTER FOAM TO ROUTER PATTERN DT8035

DRILL 8 HOLES $\varnothing 0.171$
PER SCRIBE LINES
OF MOLD DT8036 OR
REFER TO DETAIL B
ON PAGE 2

MAIN LAYUP

GELCOAT #GEL 944W005
9 oz SATIN
9 oz SATIN
FOAM
9 oz SATIN
12 oz UNIDIRECTIONAL
9 oz SATIN
RESIN
PEEL PLY

ALIGN LOWER HINGE
HOLES VERTICALLY WITH
UPPER HINGE HOLES



NOTES:

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

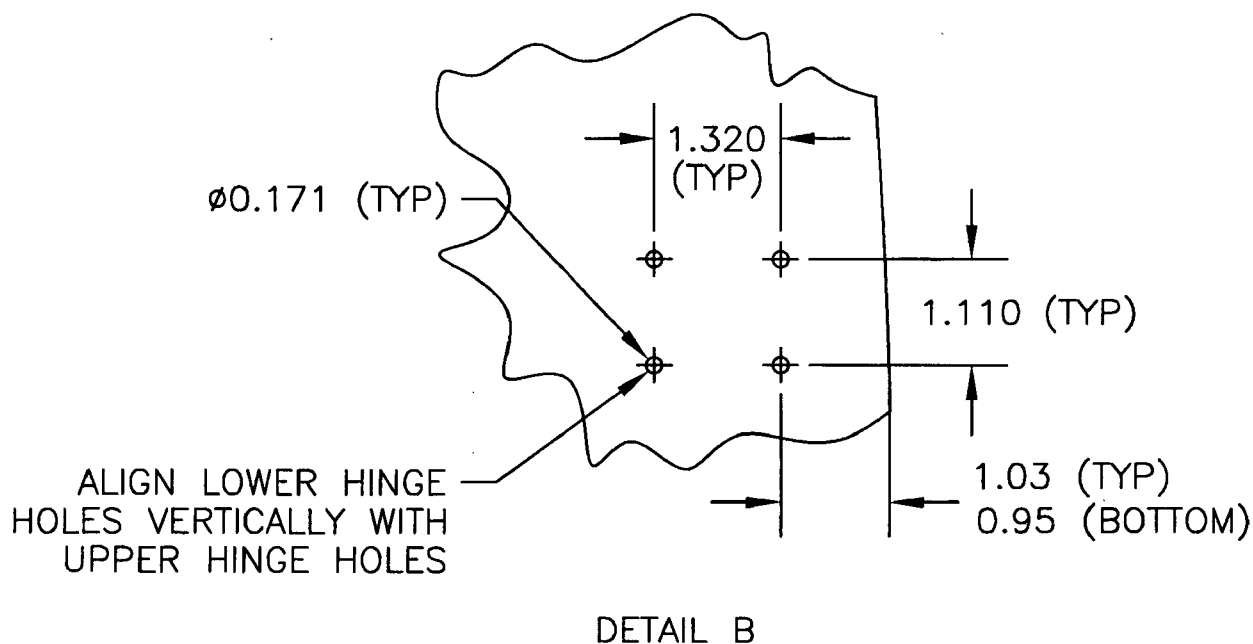
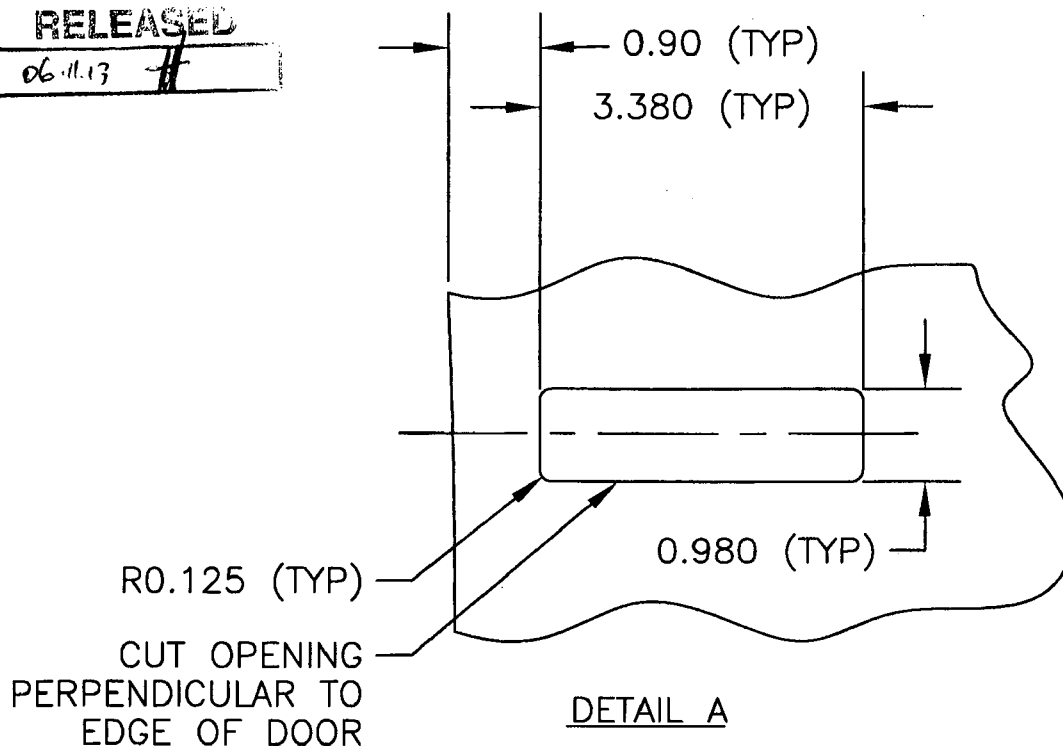
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09	TITLE AFT BAGGAGE DOOR		SCALE 1:2

RELEASED
06.11.13 [Signature]



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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24168**

Purchase Order Date 5/12/2014

PO Print Date 5/12/2014

Page Number 1 of 2

Order From :
DELASTEK INC
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7
CA

VU-DEL003

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

PAID
C244/05/12

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	819 533 5788	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 30
Ship To Phone		Currency	USD
Ship Via:	FedEx PI collect	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2445P AS PER DWG D2445 REV. D <u>B118862</u> 116 372-1	Aft Door Assembly	6/27/2014 Yes 6/27/2014		1.00 Each	\$592.76	\$592.76
Line Total:							\$592.76
2	71401-45	PROCUREMENT QUALITY CLAUSES	6/27/2014 No 6/27/2014		1.00	\$0.00	\$0.00
Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A041 quality management A042 dart noyification by supplier A043 retention of quality documents							

Note:

5/12/2014



DELASTEK Inc.
2699 5e Avenue
Local 14,
Grand-Mère, Québec G9T 2P7-
Canada
Tel.: (819) 533-5788
Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Invoice No.	57593
Customer No.	DART US

Bill To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577
Contact : Chantal Lavoie

Ship To

DART AEROSPACE LTD
1270, Aberdeen Street
Hawksbury, Ontario K6A 1K7
Canada

Telephone : 613-632-9577
Contact : Chantal Lavoie

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
17-06-2014	12-05-2014	24639	Chantal Lavoie	PO24168	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
FEDEX P1 Collect		Point de départ		Jocelyne Laurin, 221	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line #1 D350-588-041 Aft Baggage Door U of M: Chaque (D2445) Drawing N° : D2445 Rév.: D Serial # Lot # B116372 61316	

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: _____

Quality department

AQ-357

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé



Client	: DART US DART AEROSPACE	Nom Dessin	: N° D2445, AFT BAGGAGE DOOR
Numéro Job	: 61316	Numéro Article	: DKC134-0013
Numéro	: 3959	Numéro Dessin	: D2445
Numéro B.A.	:	Projet Numéro	: DK-362
Cette fois	: 2014-04-30 No. :	Révision dessin	: D
Prsht Rev.	: NC	Matériel	: Composite
Prem. fois	: - - Type :	Date Dûe	: 2014-06-30
Job précédente	: 55240	Qté:	1 Ud UNITE
Écrit par	: _____		
Vérifié & Approuvé par	: _____		
Commentaires	: N° de pièce Client: N/A		

E.O.: N/A

Feuille de Procédé Rév.: 05 ajout de l'IF134-0007 sur plusieurs séquences, numéro du moule passe de DT-8036 pour DKO-0235, numéro du moule passe de DT-8619 pour DKO-0063, ajouter IF134-0006 pour le taillage

Formulaire d'inspection: N/A

Produit additionnel

Numéro Job:



Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.200 UNITE(s)/Unit Total : 0.200 UNITE(s)
N° 83634, Frekote Loctite Wolo # de Lot: 1-42289-1

2.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation du moule N° DKO-0235 selon IG 0009.

Date: 14-05-14 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005












Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-45003-2

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0320 GALLON(s)/Unit Total : 0.0320 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61316	Numéro DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
5.0	PREP-GENERAL	Préparation du matériel
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine. Date: <u>14/05/14</u> Sceau:  		
6.0	GEL COAT	Application du Gel Coat
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire l'application du Gelcoat selon IF134-0007 Date: <u>14/05/14</u> Sceau:  		
7.0	AAC1885	Tissu à délaminer Release ply B
Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s) Tissu à délaminer Release ply B # de Lot: <u>N/A</u>		
8.0	AAC1887	Wrightlon 5200 Bleu P3
Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s) Wrightlon 5200 Bleu P3 # de Lot: <u>N/A</u>		
9.0	AC0885	Feutre de drainage N° Airweave N 10
Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)		
10.0	AC0943	Stretchlon 200 poche à vide Vert
Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)		
11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
Comment Qty.: 2.00 VERGE(s)/Unit Total : 2.00 VERGE(s) 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish N° de Lot: <u>1-44353-3</u>		
12.0	AMB0511	N° TG-13-U, Fiberglass 13 oz
Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s) N° TG-13-U, Fiberglass 13 oz N° de Lot: <u>1-36302-1</u>		
13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)		
14.0	PREP-GENERAL	Préparation du matériel
 		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Découper les tissus selon IF134-0007. Information de référence pour les tissus::		

Date: Mercredi, 2014-04-30 08:13:28

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 61316

Numéro DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

4 plis de tissus de 9.7 oz.
1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.
3 fois le sac à vide Strechlon 200.
3 fois le film perforé P-3
3 fois le feutre de drainage
2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Date: 24-04-14 Sceau:



15.0 AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)
Catalyst N° DDM-9 N° de Lot: 1-27829-1

16.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-45606-1

17.0 PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N°
DDM-9 par quantité de résine N° 411-350

Date: 14/05/14 Sceau:



18.0

LAMINAGE

Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Laminer la pièce selon IF134-0007.

Date: 14/05/14 Sceau:



19.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 12:15 Heure Curing Fin: 8:00













Date: 14/05/14 Sceau:



Date: Mercredi, 2014-04-30 08:13:28







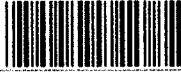









Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE		Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61316		Numéro DKC134-0013	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
20.0	AMB0286	Catalyst N° DDM-9	
Comment Qty.: 0.0042 GALLON(s)/Unit Total : 0.0042 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-45606-1</u>			
21.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.	
Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total : 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-97899-1</u>			
22.0	PREP-GENERAL	Préparation du matériel	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: <u>9-05-14</u> Sceau: 			
23.0	AAC1611	Polybond B46F	
Comment Qty.: 0.045 KIT(s)/Unit Total : 0.045 KIT(s) Polybond B46F N° de Lot: <u>1-38189-1</u>			
24.0	DKC134-0029	Foam Core N° D2445-101 (Pour AFT Baggage Door)	
Comment Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) N° de Job: <u>61319</u>			
25.0	ASSEMBLAGE	Assemblage mécanique	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Coller le Foamcore selon IF134-0007. Date: <u>15/05/14</u> Sceau:  			
26.0	BAGGING	Faire le bagging sur la pièce	
			
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure début Curing: <u>9:15</u> Heure Fin Curing: <u>10:30</u> Date: <u>15/05/14</u> Sceau:  			


Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61316	Numéro DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
27.0	AMB0286	Catalyst N° DDM-9
Comment	Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s) Catalyst N° DDM-9 N° de Lot: <u>1-27829-1</u>	
28.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
Comment	Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: <u>1-45606-1</u>	
29.0	PREP-GENERAL	Préparation du matériel
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350. Date: <u>16/05/14</u> Sceau:  	
30.0	LAMINAGE	Faire le laminage
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire le laminage des tissus de verre selon IF134-0007. Date: <u>16/05/14</u> Sceau:  	
31.0	BAGGING	Faire le bagging sur la pièce
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Laisser sécher pendant 4 heures minimum. Heure Curing Début: <u>8:15</u> Heure Curing Fin: <u>8:00</u> Date: <u>16/05/14</u> Sceau:  	
32.0	DÉMOULAGE	Démoulage de la pièce
 		
Comment	Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs Démouler la pièce en faisant bien attention aux coins & rebords. Date: <u>20-05</u> Sceau: 	

Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé

Cliant: DART US DART AEROSPACE Norm Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro Job: 61316 Numéro DKC134-0013
Numéro Job: 


Séq.: Machine ou Opération: Description :

33.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler la pièce selon IF134-0006.

Date: 20/05/14 Sceau: 

34.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler


Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1

35.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 20/05/14 Sceau: 

36.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

37.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1

38.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation et l'application du primer batisseur selon I.G. 0008

Date: 20-05-14 Sceau:  # de fiche de mélange: 6604

39.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler


Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-45373-1

40.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 22/05/14 Sceau: 

Date: Mercredi, 2014-04-30 08:13:28
Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE
Numéro Job: 61316

Nom Dessin: N° D2445, AFT BAGGAGE DOOR
Numéro DKC134-0013

Numéro Job:



Séq.: Machine ou Opération: Description :

41.0 AAC1605 Label N° D0588-041

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)
Label N° D0588-041 N° de Lot: N/A

42.0 AAC1609 Surface Veil

Comment Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s)
Surface Veil N° de Lot: 1-43570-1

43.0 AAC1220 Résine Mia-Poxy 100

Comment Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)
Résine Mia-Poxy 100 N° de Lot: 1-30093-4

44.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Comment Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot: 1-34505-1

45.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111.

Date: 23/05/14 Sceau:

46.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)
Dupont Primer N° 7704S N° de Lot: 1-54556-3

47.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-44895-1

48.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation et l'application du primer final selon I.G. 0008

Date: 26/05/14 Sceau: # de fiche de mélange: 6605

49.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs





Faire l'inspection selon le dessin N° D2445.

Date: 28/05/14 Sceau:

Date: Mercredi, 2014-04-30 08:13:28

Utilisateur: marc dubé

Feuille de Procédé

Client: DART US DART AEROSPACE	Nom Dessin: N° D2445, AFT BAGGAGE DOOR	
Numéro Job: 61316	Numéro: DKC134-0013	
Numéro Job: 		
# Séq.:	Machine ou Opération:	Description :
50.0	EMBAL / ENTREPO	Emballage & Entreposage
		
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs		
Faire l'emballage des pièces selon IG 0057		
Date: 30 MAI 2014 Sceau: 		

B116372